

Date: Monday, 11/19/2007 4:04:36 PM
 User: Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET ASSEMBLY |
| Job Number : 35860 | |
| Estimate Number : 10771 | |
| P.O. Number : <i>N/A</i> | Part Number : D3462042 |
| This Issue : 11/19/2007 S.O. No. : <i>NA</i> | Drawing Number : D3462 UNDER REVIEW <i>OK AS IS</i> |
| Prsht Rev. : NC | Project Number : N/A <i>07.11.20 DE</i> |
| First Issue : <i>NA</i> Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 34843 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 12/8/2007 Qty: 6 Um: Each |
| Checked & Approved By : <i>[Signature] 07.11.20</i> | |
| Comment : EST REV: A 05.11.18 NEW ISSUE EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------|------------------|
| 1.0 | D34621 | BRACKET ASSEMBLY |
|-----|--------|------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Base Flat Pattern

Pick:

| | | | |
|-----|-------------|-------------------|-------------------|
| Qty | Part Number | Description | Batch |
| 1 | D3462-1 | Base Flat Pattern | <i>B 33822 5X</i> |

B 34219 1X

J.J.L. 07/12/03

| | | |
|-----|--------|-----|
| 2.0 | D34623 | Lug |
|-----|--------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Flange

Pick:

| | | | |
|-----|-------------|-------------|----------------|
| Qty | Part Number | Description | Batch |
| 1 | D3462-3 | flange | <i>B 33823</i> |

J.J.L. 07/12/03

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg D3462

J.J.L. 07/12/04

| | | |
|-----|-----|---------------------------|
| 4.0 | QC9 | VISUAL WELDING INSPECTION |
|-----|-----|---------------------------|



Comment: VISUAL WELDING INSPECTION

PD 07-12-07 (6)

| | | |
|-----|-----|------------------------------|
| 5.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

J.J.L. 07/12/07 (+6 042)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/12/13
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:04:36 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 35860

Part Number: D3462042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m 105914



(6)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

BL 07-12-10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H

07/12/10

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57205*

LC 7/12/12 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/13

Job Completion



min 2007/12/12 CY

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

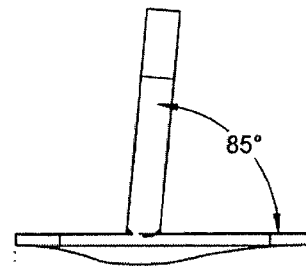
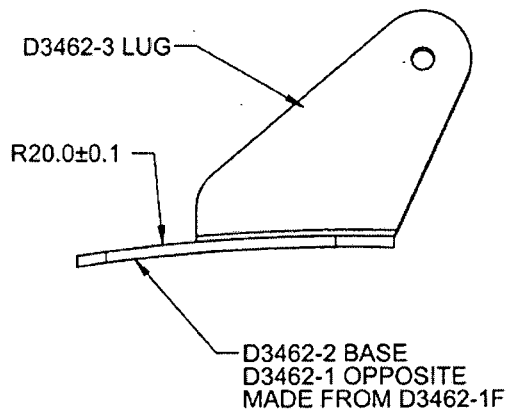
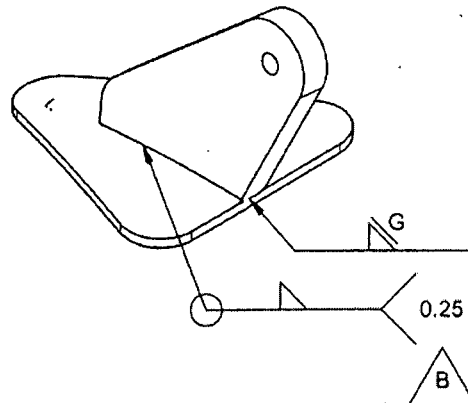
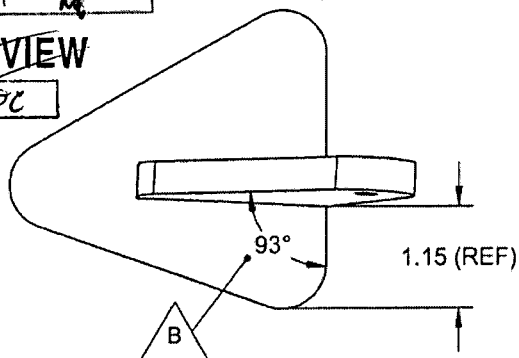
| | | | |
|------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED // | APPROVED // | DRAWING NO. D3462 | REV. B SHEET 1 OF 2 |
| DATE 05.12.05 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIMENSIONS | |

RELEASED

05.12.09

UNDER REVIEW

07.10.18 DC

OK AS IS
07.11.20 DC**D3462-042 BRACKET ASSEMBLY (SHOWN)**
D3462-041 OPPOSITE**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35860

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| | | | |
|-------------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3462 | REV. B SHEET 2 OF 2 |
| DATE 05.12.05 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |

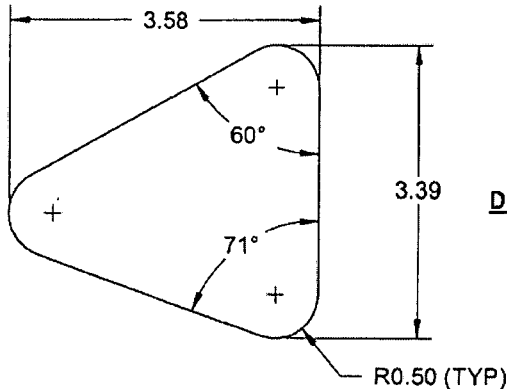
RELEASED

05.12.09 #

UNDER REVIEW

07.10.18 DC

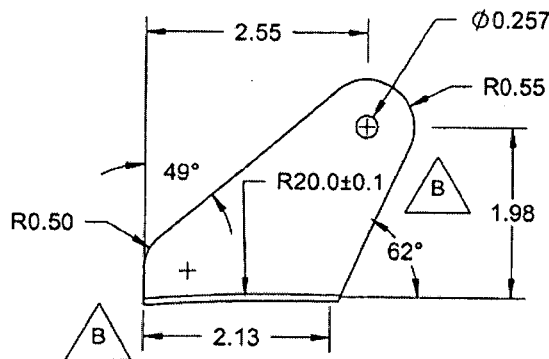
OK AS IS
07.11.20 DC



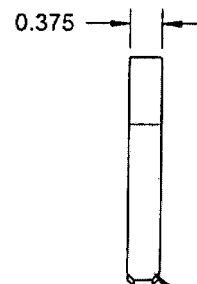
D3462-1F FLAT PATTERN

D3462-1F BASE

- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK (REF. DART SPEC. M304S11 GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010



D3462-3 LUG



0.08 x 45°
CHAMFER

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D3462-3

- 1) MATERIAL: AISI 304 SS BAR (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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